Report - ASAP ship by 1st → Friday

Work Order ID 119319

July-29-14 2:46:21 PM

119319

Item ID: D4970-041 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Windshield Deflector Assembly

Start Date: 5/15/14 **Start Qty:** 1.00 *1*

Required Date: 5/15/14 **Req'd Qty:** 1.00 *1*

Reference:

Cust Item ID:

Customer:

Approvals: **Process Plan:** W **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** *NR1*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr: D4970 / Revision Nbr: C									
100	Pick Kit	0.00							DAS 41 9-89
100						1			14-8-11
Packaging	Memo	0.00							
Packaging									
110		0.00							DAS 41 9-89
110						1			14-8-11
Small Fab	Memo	0.00							
Small Fab	- ASSEMBLE AS PER DWG.								
	- APPLY RTV LOCKTITE BETWEEN FAYING SURFACE AS PER DWG. RTV LOCKTITE B/N: 125540 EXP: 5/15								

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Item ID: D4970-041
Revision ID:
Item Name: Windshield Deflector Assembly
Start Date: 5/15/14 **Start Qty:** 1.00 *1*
Required Date: 5/15/14 **Req'd Qty:** 1.00 *1*
Reference:

Accept *N900040100*
Setup Start *NS1*
Stop *NS2*
Cust Item ID:
Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC5- Inspect part completeness to step on W/O	0.00				1			DAS 16 9-89 14/08/11
	Memo	0.00							
130 *130* SprayPaint Spray Painting		0.00				1			DAS 41 9-89 14-8-11
	Memo PRIME AS PER DWG. D4970. B/N: 128987	0.00							
140 *140* QC Quality Control	QC14- Inspect Spray Paint	0.00				1			DAS 38 9-89 14/08/12
	Memo	0.00							

325

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

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☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Item ID: D4970-041
Revision ID:
Item Name: Windshield Deflector Assembly
Start Date: 5/15/14 **Start Qty:** 1.00 *1*
Required Date: 5/15/14 **Req'd Qty:** 1.00 *1*
Reference:

Accept *N900040100*
Setup Start *NS1*
Stop *NS2*
Cust Item ID:
Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: Rhy	0.00				MF 14-8-12			
150									
Packaging	**Memo**	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	**Memo**	0.00				MCJ 14-08-13			
Quality Control									

MF 14-8-12

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

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Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

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☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other

Picklist Print

July-29-14 2:46:21 PM

Work Order ID: 119319

119319

Parent Item: D4970-041

D4970-041

Parent Item Name: Windshield Deflector Assembly

Start Date: 5/15/14 **Required Date:** 5/15/14

Start Qty: 1.00 **Required Qty:** 1.00

Comments: IPP REV:A 13.11.14 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4970-1 *D4970-1* Windshield Deflector - Lower		Manufactured	No		122767		Each	0.0000	**	1	DAS 41 9-89	14-8-11	
D4970-3 *D4970-3* Windshield Deflector - Upper		Manufactured	No		118373		Each	0.0000	**	1	DAS 41 9-89	14-8-11	
D4970-5 *D4970-5* Doubler		Manufactured	No		122216		Each	0.0000	**	2	DAS 41 9-89	14-8-11	
MS20470AD6-12 *MS20470AD6-12* Rivet		Purchased	No				Each	350.0000	**	6			

Location	Loc Qty	Loc Code			
ST310	350				
m127304	350		6	DAS 41 9-89	14-8-11

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Doc/Data	☐									
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Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

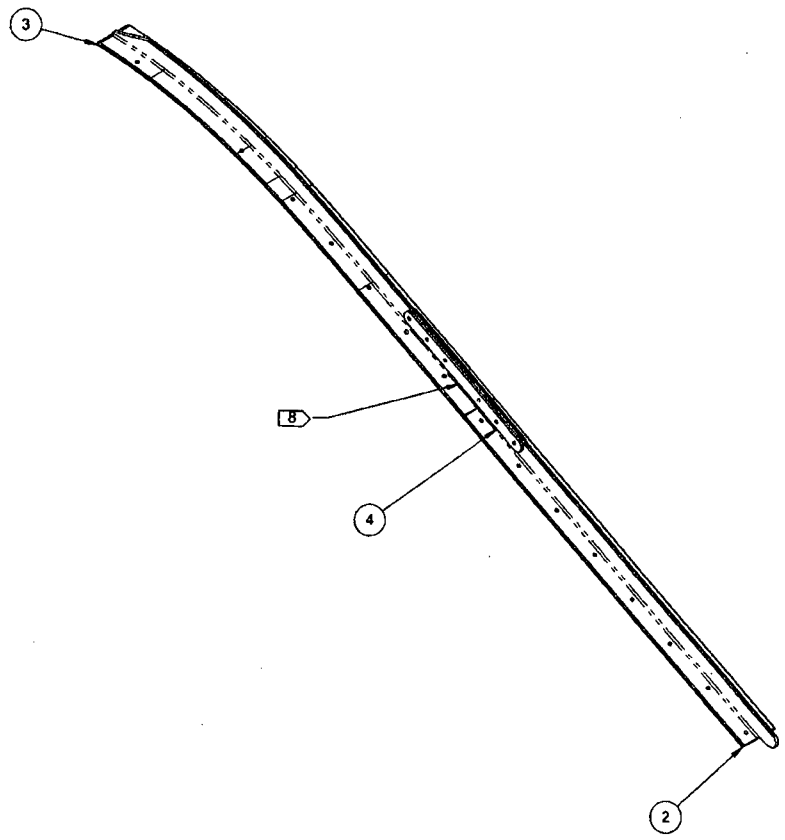
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☐ Other

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D4970-041	WINDSHIELD DEFLECTOR ASSY
2	1	D4970-1	WINDSHIELD DEFLECTOR - LOWER
3	1	D4970-3	WINDSHIELD DEFLECTOR - UPPER
4	2	D4970-5	DOUBLER
5	6	MS20470AD6-12	RIVET, SOLID, PAN HEAD



w/ 0119319

RELEASED
2014 -06- 11

D4970-041 WINDSHIELD DEFLECTOR ASSY

NOTES:
1) MATERIAL: N/A
2) FINISH: PRIME IAW MIL-P-23377J TYPE I CLASS N; 1-2 MIL MAX, AS PER QSI 005. APPLY FINISH AFTER ASSEMBLY
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
C 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4970-041", REVISION, BATCH NUMBER AND DATE OF MANUFACTURE, USING AN X-TENSION STAMP. PER QSI 044 METHOD 6.2
7) WEIGHT: 3.14 lbs (1.44 kgs)
8) APPLY RTV SEALANT LOCTITE 598 TO FAYING SURFACES

REV.	DESCRIPTION	BY	DATE
C	REVISED D4970-1 (ZN B4-3). ADDED DETAIL C (ZN C3-3). ADDED FOUR HOLES TO D4970-3 (ZN D6-5). REVISED HOLE DIMENSION FROM 0.191 TO 0.201 (ZN B4-5); REVISE NOTE 6) (ZN A8-1, A8-3, A8-4, A8-8)	AK	14.06.05
B	ADDED HOLES TO D4970-1 AND D4970-3. ADDED SHEET 5	AK	14.05.02
A	NEW ISSUE	DC	13.11.08

APPROVED

DESIGN	DC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED	HS	DRAWING NO. D4970 REV. C
MFG. APPR.	JLM	SHEET 1 OF 6
APPROVED	HS	TITLE WINDSHIELD DEFLECTOR
DE APPR.	DS	SCALE NTS
DATE	14.06.05	

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DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
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Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

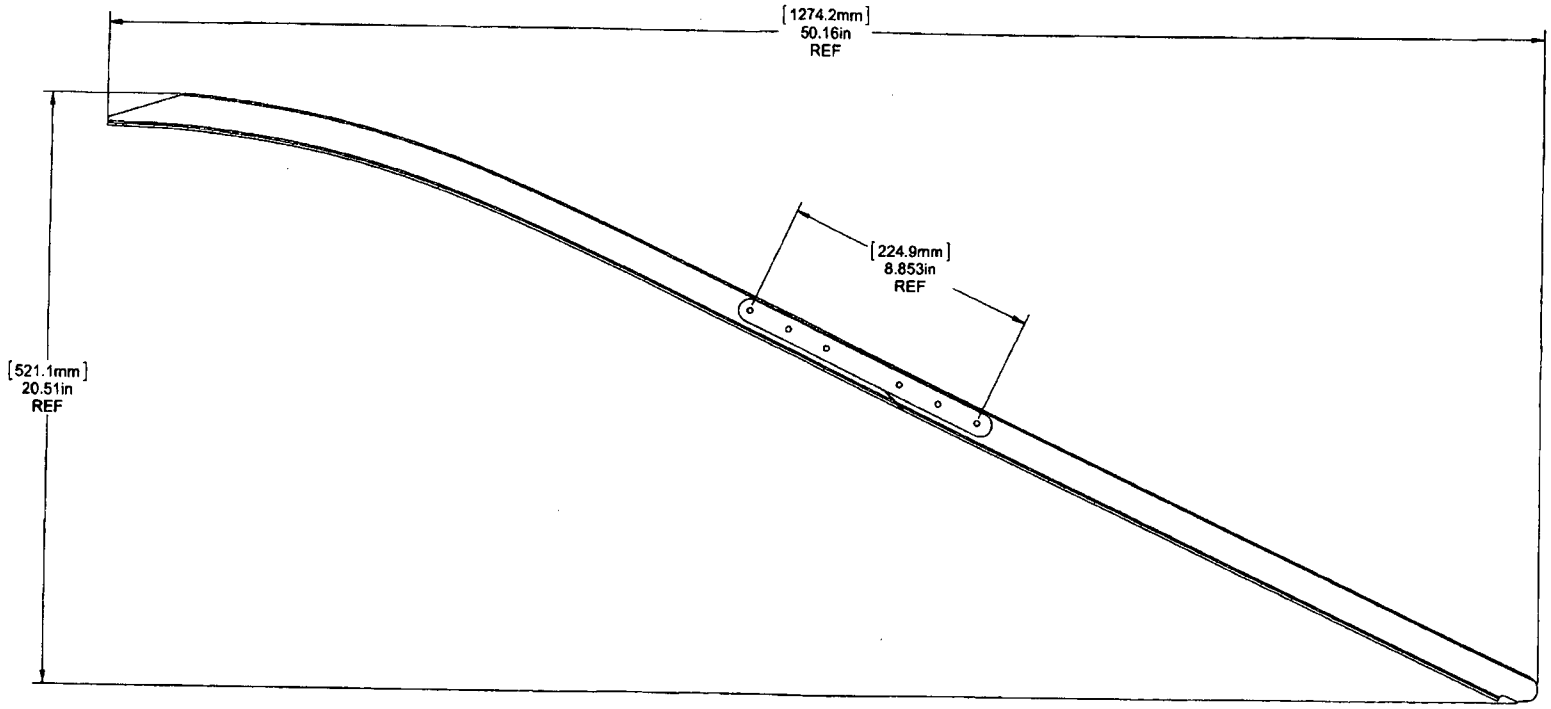
FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
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☐ Wrong Stock Pulled
☐ Other



D4970-041 WINDSHIELD DEFLECTOR ASSY
AUXILIARY VIEW

RELEASED
2014-Oct-11

APPROVED

DESIGN	DC	DART AEROSPACE LTD
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED	HS	DRAWING NO. D4970 REV. C
MFG. APPR.	JLM	SHEET 2 OF 6
APPROVED	HS	TITLE WINDSHIELD DEFLECTOR SCALE NTS
DE APPR.	DS	
DATE	14.06.05	

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